

Work Order ID 124612

September-17-14 10:52:04 AM

124612

Page 1

Item ID: D3589-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Arm

Stop

NS2

Start Date: 9/17/14

Start Qty: ~~4.00~~

4

Cust Item ID:

Required Date: 9/19/14

Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: *W*

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
100		0.00							
100 Small Fab									

100

100

Small Fab

Memo

0.00

3

FF 14-09-17

Small Fab

1- cut D3589-1 as per dwg D3589
2- chamfer both ends as per dwg D3589
3- deburr

110

QC5- Inspect part completeness to step on W/O

0.00

DAS

110

QC

Memo

0.00

3

14-09-19

9

9-89

Quality Control

120

Identify as per dwg & Stock Location *QA002*. 0.00

120

Packaging

Memo

0.00

3X

14-9-22

DAS

26

9-89

Packaging

Work Order ID 124612

September-17-14 10:52:04 AM

124612

Page 2

Item ID: D3589-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Arm

Stop

NS2

Start Date: 9/17/14 Start Qty: 4.00

4

Cust Item ID:

Required Date: 9/19/14 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

130

QC21- Final Inspection - Work Order Release

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

QC

Memo

Quality Control

0.00

0.00

MLJ 14-09-23

MLJ 14-09-22

Picklist Print

September-17-14 10:52:03 AM

Page 1

Work Order ID: 124612

124612
D3589-1

Parent Item: D3589-1

Parent Item Name: Arm

Start Date: 9/17/14

Required Date: 9/19/14

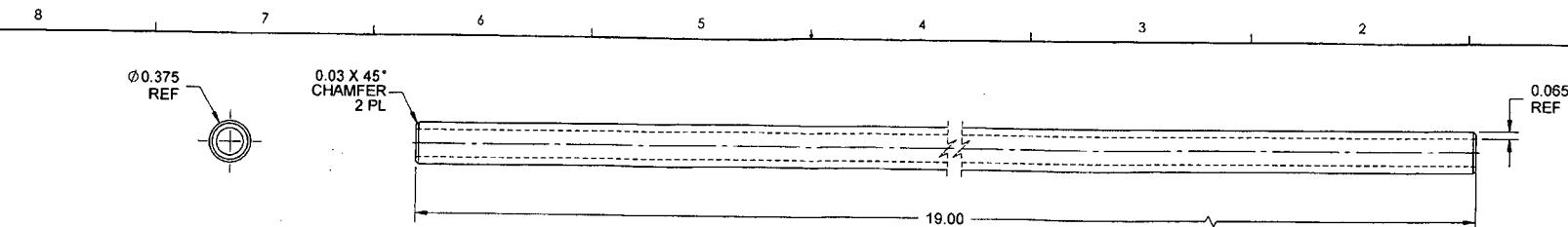
Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 08-05-29 new issue DD verified by:EC IPP Rev:B 09-02-20 rev.b asper dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.375W.065 *M304TR0 375W 065* 304 RD Tube .375 x .065W		Purchased	No			100	f	9.8380	1.65	7		DAS 30 9-89	14/09/17

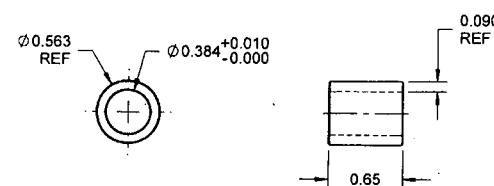
Location	Loc Qty	Loc Code
MAT016	9.838	
✓124768	9.838	9.838



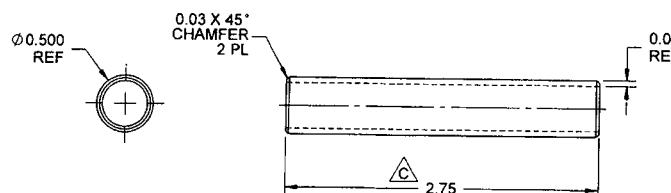
D3589-1 ARM



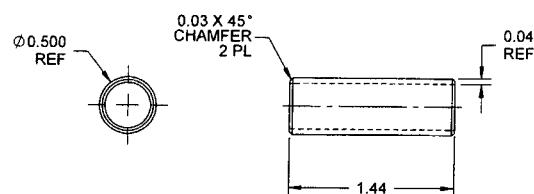
D3589-3 ARM GUIDE



D3589-23 ARM GUIDE



D3589-5 LATCH GUIDE



D3589-21 LATCH GUIDE

D3589-1/-3/-5/-21/-23 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING
D3589-1: 0.375 O.D. X 0.065 WALL (REF. DART SPEC M304TR0.375W.065)
D3589-3: 0.500 O.D. X 0.058 WALL (REF. DART SPEC M304TR0.500W.058)
D3589-5/-21: 0.500 O.D. X 0.049 WALL (REF. DART SPEC M304TR0.500W.049)
D3589-23: AISI 304/316 STAINLESS STEEL ROUND BAR PER ASTM A276
(REF. DART SPEC M304R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: - D3589-1 = 0.34 lbs
- D3589-3 = 0.01 lbs
- D3589-5 = 0.06 lbs
- D3589-21 = 0.03 lbs
- D3589-23 = 0.02 lbs

W024602

RELEASE
2012-07-16
AM

DESIGN	<i>1</i>	DART AEROSPACE LTD	
DRAWN	<i>b</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>RP</i>	DRAWING NO.	
MFG. APPR.	<i>RP</i>	REV. C	
APPROVED	<i>RP</i>	D3589	SHEET 4 OF 8
DE APPR.	<i>RP</i>	TITLE	SCALE
DATE	12.07.04	LATCH ASSEMBLY	

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8 7 6 5 4 3 2 1